

Date: Thursday, 3/8/2007 12:32:40 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEB
Job Number	31114			
Estimate Number	10482			
P.O. Number	N/A		Part Number	D2923
This Issue	3/8/2007 S.O. No. N/A		Drawing Number	D2923 REV.A
Prsh Rev.	NC		Project Number	N/A
First Issue	N/A		Drawing Revision	A
Previous Run	29229		Material	N/A
Written By			Due Date	4/3/2007
Checked & Approved By	JB 07.03.08		Qty:	3
Comment	Est. B	02.07.26	Updated Location	RF

Additional Product

Job Number:		
Seq. #:	Machine Or Operation:	Description :
1	D26005108	Extrusion 'I Beam' thin
O. Number		
This Issue		
Prsh Rev.	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
First Issue	D2600-5-108 Extrusion 'I Beam' thin	
Previous Run	Batch: B 24410	
Written By	JB 7-3-12	
Comments	Unit: Each	
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
		
Comments	Comment: LANDING GEAR RESOURCE 1	
	Cut D2600-5 Extrusion to length as per Dwg D2923.	
	Deburr ends	
3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
		
Comments	Comment: LANDING GEAR RESOURCE 1	
	1- Drill pilot holes in web as per Dwg D2923 using drill jig DT8481	
	2- Open holes to finish size as per Dwg D2923.	
	3- Deburr	
4.0	QC5	INSPECT WORK TO CURRENT STEP
		
Comments	Comment: INSPECT WORK TO CURRENT STEP	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
Comments	Comment: HAND FINISHING RESOURCE #1	
	Chemical Conversion Coat as per QSI 005 4.1	
	JB 7-3-12	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 31114

Part Number: D2923

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 07-01-21 (5)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

BE 07-01-21 (5)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DO 7/03/01

Job Completion



U 07-03-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

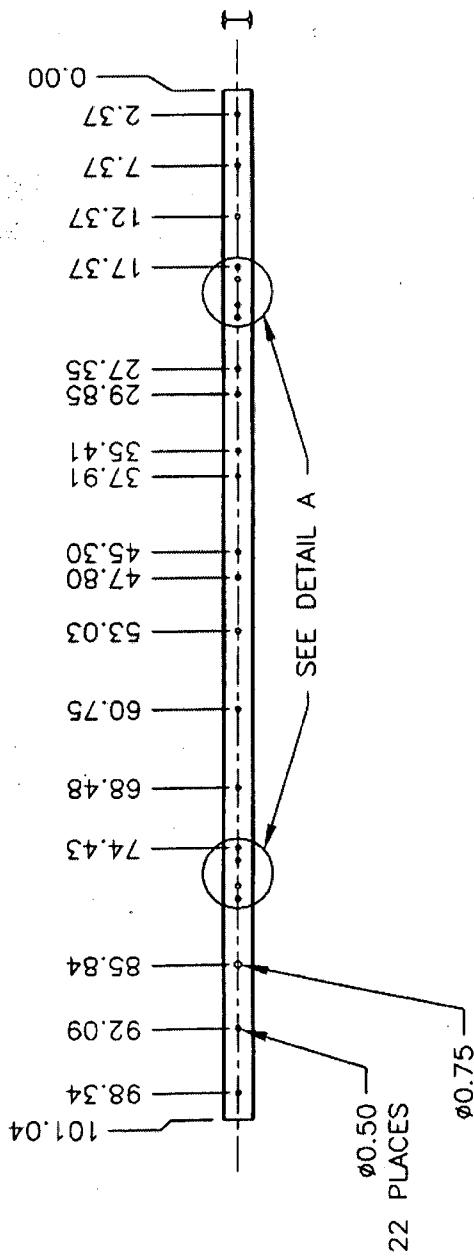
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

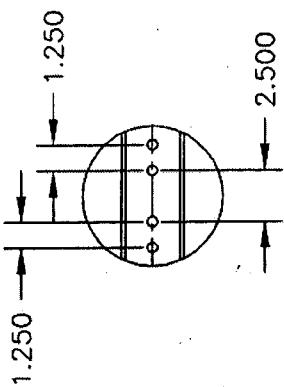
NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2923	REV. A SHEET 1 OF 1
DATE 99.10.14		TITLE WEB	SCALE 1:18
A	99.10.14	NEW ISSUE	



DETAIL A
SCALE 1:9



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31114

MAKE FROM D2600-5 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED